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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3913-041
Job Sheet 176187



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/18/18

Job Tracking No:

Due Date: 5/21/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/18/18	0.00	0.00	Start Up Large Fab-5		DC 2018-05-24
100	Large Fab	1 pcs		5/19/18	0.00	10.00	Large Fab 1		C. 2018-05-24
110	QC	1 pcs		5/19/18	0.00	0.00	QC9		DB
120	QC	1 pcs		5/19/18	0.00	0.00	QC5		DB
125	HandFinish	1 pcs		5/19/18	0.00	0.29	HandFinish2		BE 18-06-04
130	Powdercoat	1 pcs		5/19/18	0.00	0.93	Powdercoat2		BR 18-6-21
135	Packaging	1 pcs		5/19/18	0.00	0.00	Packaging1		BR 18-6-5
140	QC	1 pcs		5/19/18	0.00	0.00	QC3		BR 18-6-5
150	HandFinish	1 pcs		5/21/18	0.00	0.50	HandFinish4		BR 18-6-5
160	QC	1 pcs		5/21/18	0.00	0.00	QC5		BR 18-6-5
170	Packaging	1 pcs		5/21/18	0.00	0.00	Packaging3-2		BR 18-6-5
180	QC21-SA	1 Ea		5/21/18	0.00	0.00	QC21		21 JUN 05 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit



Container No: S074124



Part: D3913-041

Job No: 176187

Serial No/Batch: S074124

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

M138839.
START: 11:45.
OV: T: 375°
FINISH: 12:00.

Date: 05/24/18

Plex 4/18/18 12:55 PM Dart.Gagnon.Michelle

003649

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5051665
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5061862
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5058261
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5061852
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5066274
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5058004
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5061468
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5058004 5069386
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5062521
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5058574
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5060229
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5057511
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5058263
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5072192
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5072934
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5054936
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5060244
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	50741958
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	F966435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5042091
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5062377
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5068663
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5059025 40
				5067467 (40)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	72	0
	D3913-1	1	15	0
	D3913-15	1	18	0
	D3913-3	1	17	0
	D3913-7	2	15	0
	D3913-9	1	9	0
	D3916-041	2	20	0
	D3916-5	3	20	0
	D4016-1	3	4	0
	D4017-7	3	57	0
	D4017-9	2	16	0
	D4020-11	2	27	0
	D4021-1	3	42	0
	D4034-041	1	7	0
	D4034-043	1	7	0
	D4672-1	2	50	0
	M304EX0.75-16F	33	1,120	0
150-HandFinish	AN3-10A	6	237	0
	D2931	2	1,080	0
	D4021-5	2	26	0
	MS20600-AD4W3	2	273	0
	MS21042L3	6	2,861	0
	NAS1149F0332P	12	3,047	0

Part Specifications

Specifications could not be found.

Master Unit 003062



Job No 176187